

Work Order ID 53459

November 9, 2009 10:13:37 AM



Page 1

Item ID: D3178-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Nut Plate

Start Date: 05/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

JUL 09-11-08

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Memo
D3178	Rev A	

105



Waterjet

0.00

BS 9-11-18

FLOW CNC Waterjet

.061
.062

Memo

A
A

(7)

120



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

Memo

0.00

BS 9-11-18

130



QC

QC8- Inspect parts - second check

0.00

Quality Control

Memo

0.00

27 Oct 11-19

(7) p

Work Order ID 53459

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Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1- C'sink D3178-1 holes as per Dwg D3178-2- Deburr

150



QC5- Inspect part completeness to step on W/O

0.00

27/11/23

QC

Memo

0.00

Quality Control

160



Chemical Conversion Coat per QSI005 4.1

0.00

27/11/24

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 53459

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Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

QC3- Inspect Part Finish

0.00

Quality Control

180



Small Fab

Small Fab

0.00

0.00

Small Fab

Memo

Assemble as per Dwg D3178

190



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

Work Order ID 53459

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Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

200

Identify as per dwg & Stock Location: 72

0.00



Packaging

Packaging

Memo

0.00

CS14/30 07

210

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/11/30 08

B/09-11-30
07

Picklist Print

Page 1

November 9, 2009 10:13:36 AM

Work Order ID: 53459



Parent Item: D3178-041RevA



Parent Item Name: Nut Plate

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments: IPP REV: B NOW ON WATERJET JLM VERIFIED BY:DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS052H328.063



Purchased

No

180

sf

127.3237

0.1465

4000



AB 9-11-18

5052-H32.063 Sheet

m6061 T65.063

This Batch only

See Drawing Attached

MS20426AD3A3 10011126



Purchased

No

180

Each

7,861.000

32.0000



110551

Warehouse

Location

Main Warehouse

MAT 110551

Loc Qty

Loc Code

127.3237

110551

103755

1.3237

107276

30

112442

96

⑦

RIVET

17681

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

7861

104374

3861

110398

4000

MS21059L3



Purchased

No

100

Each

305.0000

16.0000



Nut Plate

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

305

109962

11

111925

294

DART AEROSPACE LTD	Work Order:	53459
Description: Nut Plate	Part Number:	D3178-1
Inspection Dwg: D3178 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	PR	Audited by:	S	Prototype Approval:	N/A
Date:	9-11-08	Date:	09/11/08	Date:	N/A

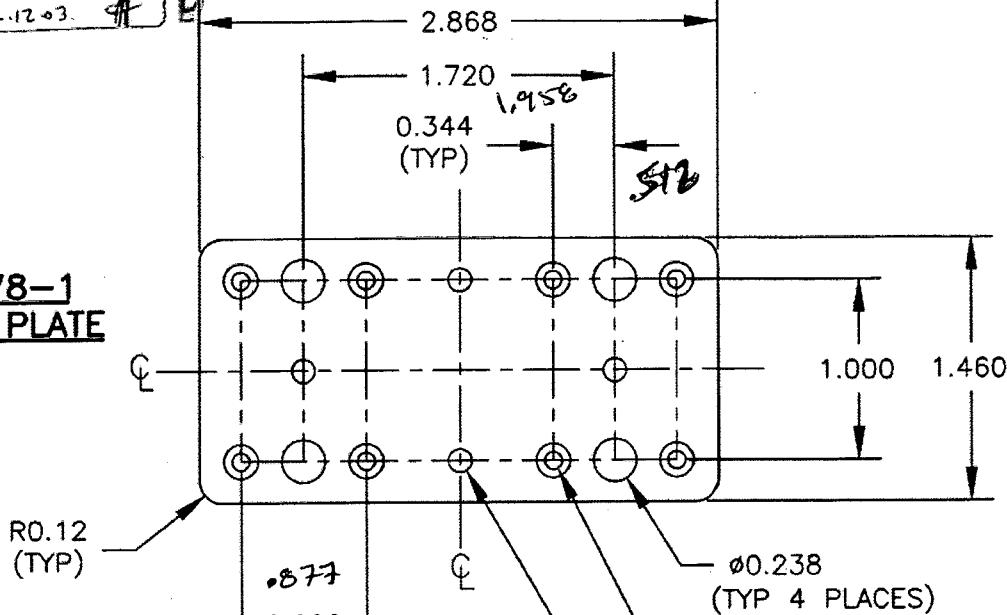
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	P/O K10017	KJ/RF ✓ ✓

DART

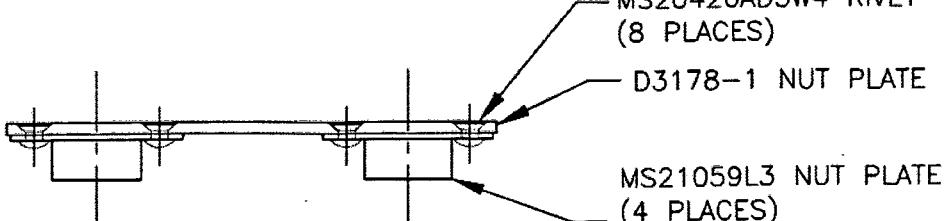
DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[initials]</i>	APPROVED	<i>[initials]</i>	DRAWING NO. D3178 REV. A
DATE	02.12.03	TITLE	NUT PLATE	SCALE 1:1
	A	02.12.03	NEW ISSUE	

RELEASED

02.12.03

D3178-1
NUT PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53459
B09-15

D3178-041
NUT PLATE**NOTES, D3178-1 NUT PLATE:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINES
- 2) MATERIAL: 5052-H32/H34 SHEET 0.063 THICK (QQ-A-250/8) USE 6061-T6
(REF DART SPEC. M5052H32S.063)
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

09/11/09